

Date: Thursday, 2/21/2008 9:26:03 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 37564	
Estimate Number : 10530	
P.O. Number :	Part Number : D2571
This Issue : 2/21/2008 S.O. No. :	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 37282	Material :
Written By :	Due Date : 3/15/2008 Qty: 10 Um: Each
Checked & Approved By : <u>080221</u>	
Comment : Est: 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101007

7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: B 34875 r108/02/27

10

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. SN Double check by: SNP10

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

SN 08/03/25

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

SN

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SN 08/03/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: Fault Category: Prod / machined parts NCR: Yes No DQA: A2 Date: 08/04/14
D412-742 QA: N/C Closed: 12 Date: 08/04/14

NCR: <u>37564</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/03/26</u>	<u>2.0</u>	<u>One saddle is scrap because the hole location is off by .050". The dimension of .500" was .438.</u>	<u>[Signature]</u>	<u>Scrap and destroy and Rep'te Qty (41)</u> <u>R# 34875</u>	<u>S.F.</u> <u>08/03/26</u>	<u>[Signature]</u> <u>08/03/26</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>08/03/26</u>
		<u>R.C. Origin was taken not properly. operator error.</u>						

NOTE: Date & initial all entries

Date: Thursday, 2/21/2008 9:26:03 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 37564

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

RP 08/04/02

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

08/04/03

10X

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

BR

08-04-03

10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

HS

AS

08-04-03

10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST432

AS

08/04/04

10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



W 08/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37564
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.000		
F	0.490	0.510		.499	.499	.501	.502		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.498	.502	.502	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.569	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.496	1.500	1.500	1.500		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.873	3.873	3.874		
P	0.115	0.135		.123	.125	.125	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.126	.127	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.961		
V	0.230	0.250		.241	.240	.241	.240		
W	0.115	0.135		.120	.118	.124	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.762	.762	.762	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.267	.267	.267	.271		
AH	0.240	0.260		.251	.254	.250	.250		
AI	2.000	2.020		2.000	2.000	2.001	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	8.8
Date:	08/03/21

Audited by:	20
Date:	08/04/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 37564
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.502	.502	.501	.500		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.377	.377	.377	.377		
I	0.490	0.510		.501	.508	.500	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.570	.570	.572		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.253	.252		
S	0.115	0.135		.132	.132	.130	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.961	2.961	2.961		
V	0.230	0.250		.240	.240	.238	.235		
W	0.115	0.135		.122	.122	.125	.126		
X	0.308	0.313		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.368	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.634	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.387	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.267	.267	.250	.250		
AH	0.240	0.260		.254	.254	.250	.250		
AI	2.000	2.020		2.000	2.001	2.000	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: RF
Date: 08/03/26

Audited by: RF
Date: 08/04/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 37564
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	.441				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.750				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.501	.501				
G	0.257	0.262	DT8683	.258	.266				
H	0.375	0.380	DT8684	.376	.378				
I	0.490	0.510		.502	.504				
J	1.174	1.184		1.179	1.178				
K	0.558	0.578		.570	.572				
L	1.174	1.184		1.179	1.178				
M	1.490	1.500		1.500	1.494				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.127	.126				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.251	.250				
S	0.115	0.135		.127	.134				
T	0.178	0.198		.184	.188				
U	2.940	2.980		2.967	2.966				
V	0.230	0.250		.240	.241				
W	0.115	0.135		.127	.126				
X	0.308	0.313		.309	.309				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.362	.363				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.628	.632				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.130	.131				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.250	.253				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									






Measured by: <i>ST</i>
Date: 05/03/27

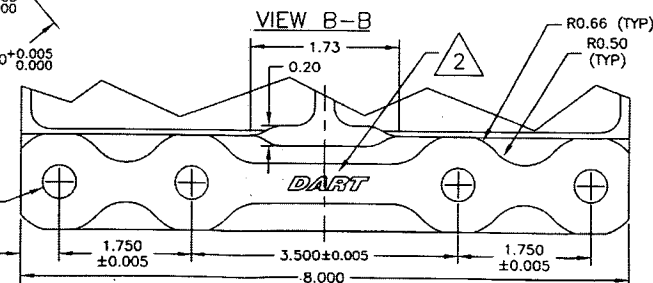
Audited by: <i>RP</i>
Date: 05/16/02




Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES: TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART AEROSPACE LTD. HARNESSBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2571
DATE 05.07.13		TITLE OUTER FWD SADDLE
		REV. 1 OF 2 SHEET 1 OF 2 SCALE 2:

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WORK ORDER
NO. 37564

DETAIL C
SCALE 4:3